


1. BREAK ALL SHARP CORNERS (.015/.03).


 <b>RED BARN MACHINE</b>	
<b>TITLE</b> KST UNIQUE SERIES SWAGING TOOL; SECONDARY SEAT	
<b>DWG NO.</b>	<b>REV</b> 2
TOOL# (see chart)-13	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE NTS DATE 4-4-08 SHEET 8 of 9	



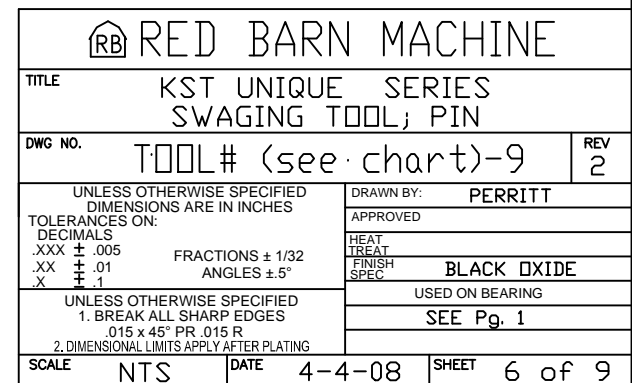
[illegible]

## NOTES

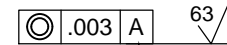
1. BREAK ALL SHARP CORNERS (.015/.03).

 <b>RED BARN MACHINE</b>			
<b>TITLE</b> KST UNIQUE SERIES SWAGING TOOL; PRIMARY SEAT			
<b>DWG NO.</b> TOOL# (see chart)-11			<b>REV</b> 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1  FRACTIONS ± 1/32 ANGLES ± 5°		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b>  <b>HEAT TREAT</b> FINISH      BLACK OXIDE SPEC  USED ON BEARING  <b>SEE Pg. 1</b>	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
<b>SCALE</b> NTS	<b>DATE</b> 4-4-08	<b>SHEET</b> 7 of 9	






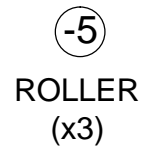





## GUIDE

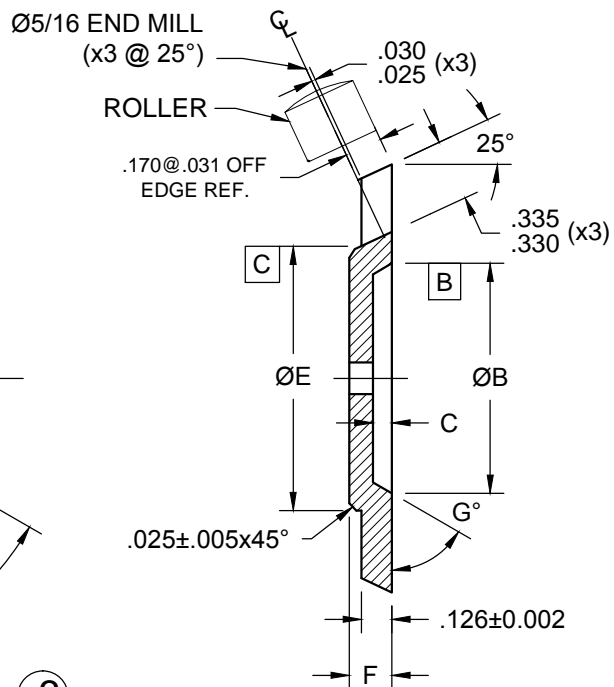
 <b>RED BARN MACHINE</b>	
<b>TITLE</b> KST UNIQUE    SERIES SWAGING TOOL; GUIDE	
<b>DWG NO.</b> TOOL# (see chart)-7	<b>REV</b> 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> <b>PERRITT</b> APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING <b>SEE Pg. 1</b>
<b>SCALE</b> NTS	<b>DATE</b> 4-4-08
<b>SHEET</b> 5 of 9	





 <b>RED BARN MACHINE</b>			
<b>TITLE</b> KST UNIQUE SERIES SWAGING TOOL; ROLLER (QTY. 3)			
<b>DWG NO.</b> TOOL# (see chart)-5			<b>REV</b> 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		<b>DRAWN BY:</b> PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
<b>SCALE</b> NTS	<b>DATE</b> 4-4-08	<b>SHEET</b> 4	of 9






SECTION A-A

[illegible]

1. BREAK ALL SHARP CORNERS (.015/.03).

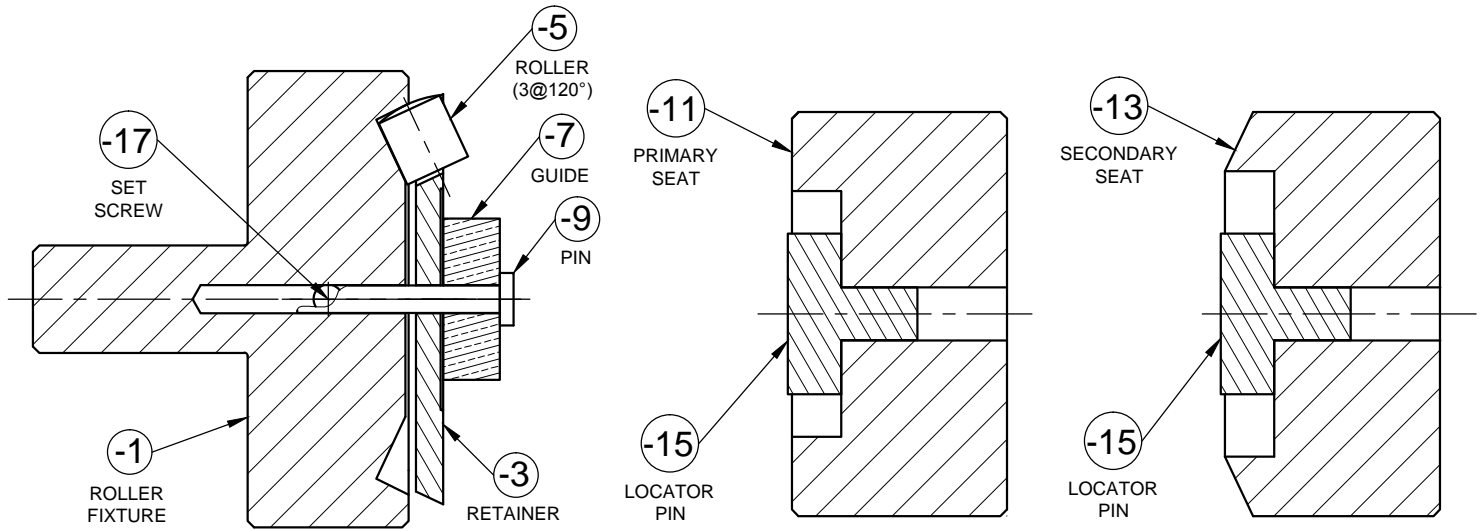
 <b>RED BARN MACHINE</b>			
<b>TITLE</b> KST UNIQUE SERIES SWAGING TOOL; RETAINER			
<b>DWG NO.</b> TOOL# (see chart)-3			<b>REV</b> 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		<b>DRAWN BY:</b> PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
<b>SCALE</b> NTS	<b>DATE</b> 4-4-08	<b>SHEET</b> 3	of 9







REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED -3 END MILL CENTER LINE FROM .154±.015 FROM EDGE TO .170±.031 FROM EDGE, AND ADDED RST161W3228.	6/16/08	WP	
2	CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE. REMOVED -1 AUX. VIEW.	7/7/08	WP	DW



NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.


BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
P2A2360 (PSI)	KSTP2A2360
KR4-CEGB	KSTKR4CEGB

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	SEE CHART	SECONDARY SEAT	SEE CHART	8
		-15	SEE CHART	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE			
TITLE KST UNIQUE SERIES TRI-ROLLER SWAGING TOOLS			
DWG NO. TOOL # (SEE CHART ABOVE)			REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS .XXX ± .005		HEAT TREAT LISTED PER ITEM	
FRACTIONS ± 1/32		FINISH LISTED PER ITEM	
ANGLES ± 5°		USED ON BEARING	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		SEE ABOVE	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 4-4-08	SHEET 1 of 9	



[illegible]

 <span style="font-size: 48pt; font-family: serif;">RED BARN MACHINE</span>			
TITLE			
DWG NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: <b>PERRITT</b> APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE	NTS	DATE	8-15-07
		SHEET	1 of 1



NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

USED ON MODEL ?     	DRAWN BY: PERRITT	<div><div>RB</div>RED BARN MACHINE</div> <div>TITLE</div> <div>TITLE</div>	
	CHECKED		
	HEAT TREAT		
	FINISH SPEC		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	DWG NO.	REV.
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS	DATE 1-28-06 SHEET 1 of 1